

# Work Order ID 58665

Thursday, May 13, 2010 11:09:35 AM



Page 1

Item ID: D3914-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Long Basket Lid Assembly (350)

Start Date: 5/13/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 5/24/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

*mf*

Date:

*10-5-13*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3914	A

100 Weld per dwg A/R S.S. rod Batch: *111679* 0.00



Large Fab

Large Fab

Memo

0.00

- 1- assemble ribs , weld as per dwg D3914 using DT9607A
- 2- weld hinge (3) and Mounting brackets as per dwg D3914
- \*\*\*inspect before welding mesh\*\*\*
- 3- tack weld mesh on basket as per dwg D3914
- \*\*\*make sure to place mesh correctly on lid, check with label plate before tacking mesh\*\*\*

*10.05.20*  
*(Training)*

*1 Cpl 10.05.19*

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00



QC

Memo

0.00

Quality Control

*① PD 10.05.20*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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**NOTE:** Date & initial all entries

**Work Order ID 58665**

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Item ID: D3914-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Long Basket Lid Assembly (350)

Start Date: 5/13/2010 Start Qty: 1.00

Cust Item ID:

Required Date: 5/24/2010 Req'd Qty: 1.00

Customer:




Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00  0.00	= 7 m-l 10/05/21			(1X)			
160  Packaging Packaging	Identify as per dwg & Stock Location: <del>RF</del> Small Fab Memo u1058778	0.00  0.00	SAD 10-05-21			(1)			
170  QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00  0.00	10/05/25						MF 10-5-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

Thursday, May 13, 2010 11:09:35 AM

Page 1

Work Order ID: 58665

Parent Item: D3914-041

Parent Item Name: Long Basket Lid Assembly (350)

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC



Start Date: 5/13/2010

Required Date: 5/24/2010

Start Qty: 1.00



Required Qty: 1.00



Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	---------------	----------------	--------

D2581  Mounting Bracket		Manufactured	No			100	Each	36.0000	2		<i>lpl 10.05.18</i>	
---	--	--------------	----	--	--	-----	------	---------	---	---	---------------------	--

Location	Loc Qty	Loc Code
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WA	36	
46086	2	
51745	2	
57185	9	
58301	23	

D2728-3  Dart Logo label		Manufactured	No			140	Each	0.0000	1		<i>SAD 10-05-21</i>	
--	--	--------------	----	--	--	-----	------	--------	---	---	---------------------	--

D3914-1  Rib		Manufactured	No			100	Each	6.0000	2		<i>lpl 10.05.18</i>	
--	--	--------------	----	--	--	-----	------	--------	---	---	---------------------	--

Location	Loc Qty	Loc Code
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WA	6	
58241	2	
58585	4	

D3914-7  Rib		Manufactured	No			100	Each	4.0000	2		<i>lpl 10.05.18</i>	
--	--	--------------	----	--	--	-----	------	--------	---	---	---------------------	--

Location	Loc Qty	Loc Code
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WA	4	
58242	4	

*B58584 → ②*

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Work Order ID: 58665

Parent Item: D3914-041

Parent Item Name: Long Basket Lid Assembly (350)









Start Date: 5/13/2010

Required Date: 5/24/2010

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
D4016-3  Hinge Half, Lid		Manufactured	No			100	Each	19.0000	3		<i>EC 10.05.18</i>	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>		<i>B58595 → ②</i>		
				ST109		7				<i>①</i>		
					57574	7						
				ST116		12						
					58243	12						
D4018-5  Rib		Manufactured	No			100	Each	12.0000	9		<i>EC 10.05.18</i>	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>		<i>B58594 → ⑨</i>		
				WA		12						
					58244	12						
D4020-5  Mesh (350 Basket Long, Lid)		Manufactured	No			100	Each	2.0000	1		<i>EC 10.05.18</i>	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>		<i>1</i>		
				WA	<i>B58483</i>	2						
					58245	2						
D4021-3  Data Plate		Manufactured	No			100	Each	3.0000	1		<i>EC 10.05.20</i>	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>		<i>1</i>		
				WA	<i>58616</i>	3						
					<i>58616</i>	1						
					<i>58616</i>	2						

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Work Order ID: 58665



Parent Item: D3914-041



Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 5/13/2010

Required Date: 5/24/2010

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
D4035-041  Lid Rib Assembly, Fwd (350 Basket)		Manufactured	No			100	Each	2.0000	1			
<div> <div>Location</div> <div>WA</div> <div>58192</div> </div> <div> <div>Loc Qty</div> <div>2</div> <div>2</div> </div> <div> <div>Loc Code</div> <div>58591 → ①</div> </div>												
D4035-043  Lid Rib Assembly, Aft (350 Basket)		Manufactured	No			100	Each	2.0000	1			
<div> <div>Location</div> <div>WA</div> <div>58193</div> </div> <div> <div>Loc Qty</div> <div>2</div> <div>2</div> </div> <div> <div>Loc Code</div> <div>58587 → ①</div> </div>												
D4086-210  Placard, Max Load		Manufactured	No			140	Each	4.0000	1			
<div> <div>Location</div> <div>ST112</div> <div>56978</div> </div> <div> <div>Loc Qty</div> <div>4</div> <div>4</div> </div> <div> <div>Loc Code</div> <div>SAD 10-05-21</div> </div>												

lpl 10-05-20

lpl 10-05-20

58587 → ①

SAD 10-05-21

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Page 3

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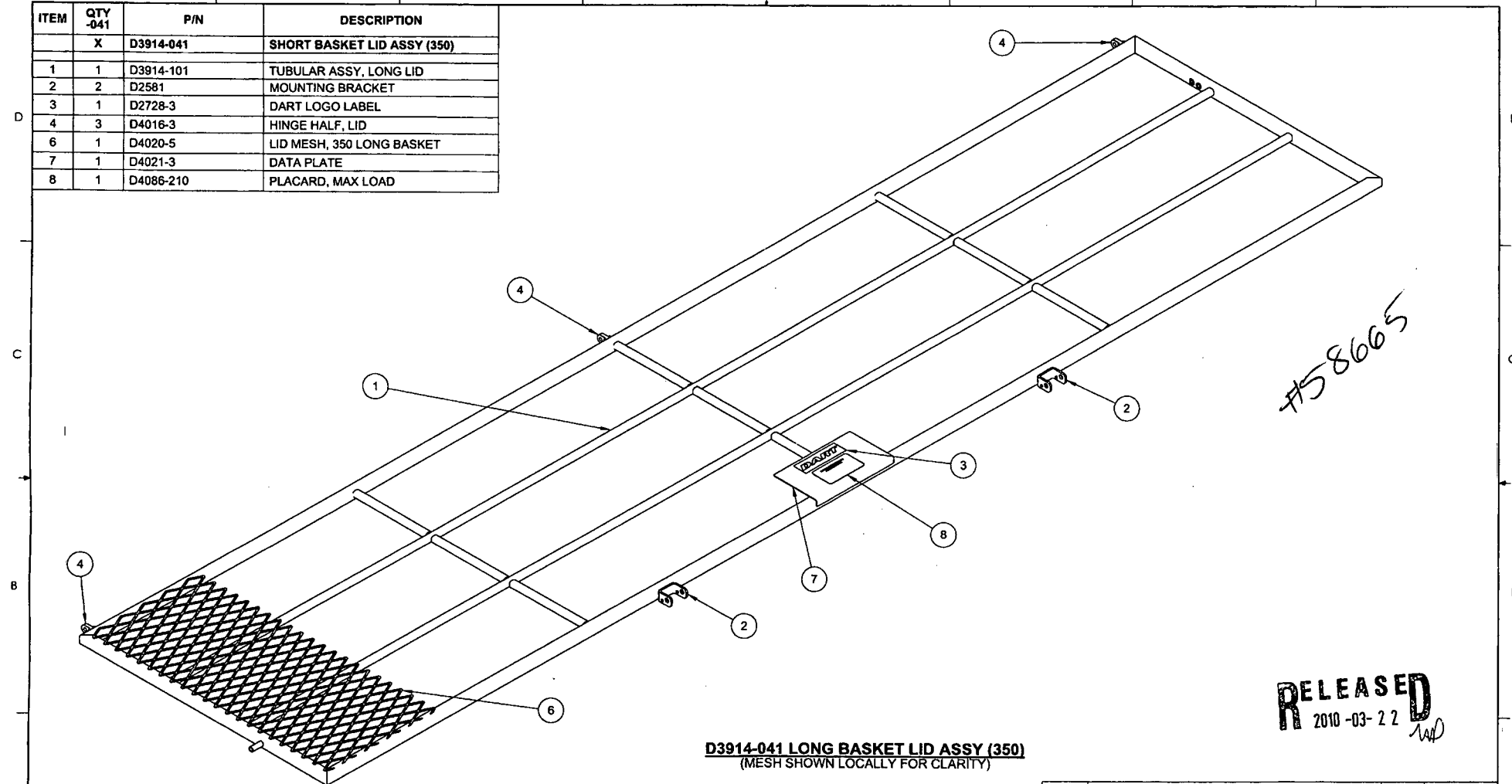
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**NOTE:** Date & initial all entries

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3914-041	SHORT BASKET LID ASSY (350)
1	1	D3914-101	TUBULAR ASSY, LONG LID
2	2	D2581	MOUNTING BRACKET
3	1	D2728-3	DART LOGO LABEL
4	3	D4016-3	HINGE HALF, LID
6	1	D4020-5	LID MESH, 350 LONG BASKET
7	1	D4021-3	DATA PLATE
8	1	D4086-210	PLACARD, MAX LOAD



**D3914-041 LONG BASKET LID ASSY (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

**RELEASED**  
2010-03-22

A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS		
DRAWN	JPH		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.03.16		
		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA DRAWING NO. <b>D3914</b> TITLE <b>LONG BASKET LID ASSY (350)</b> SCALE <b>NTS</b> SHEET 1 OF 4 REV. A <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

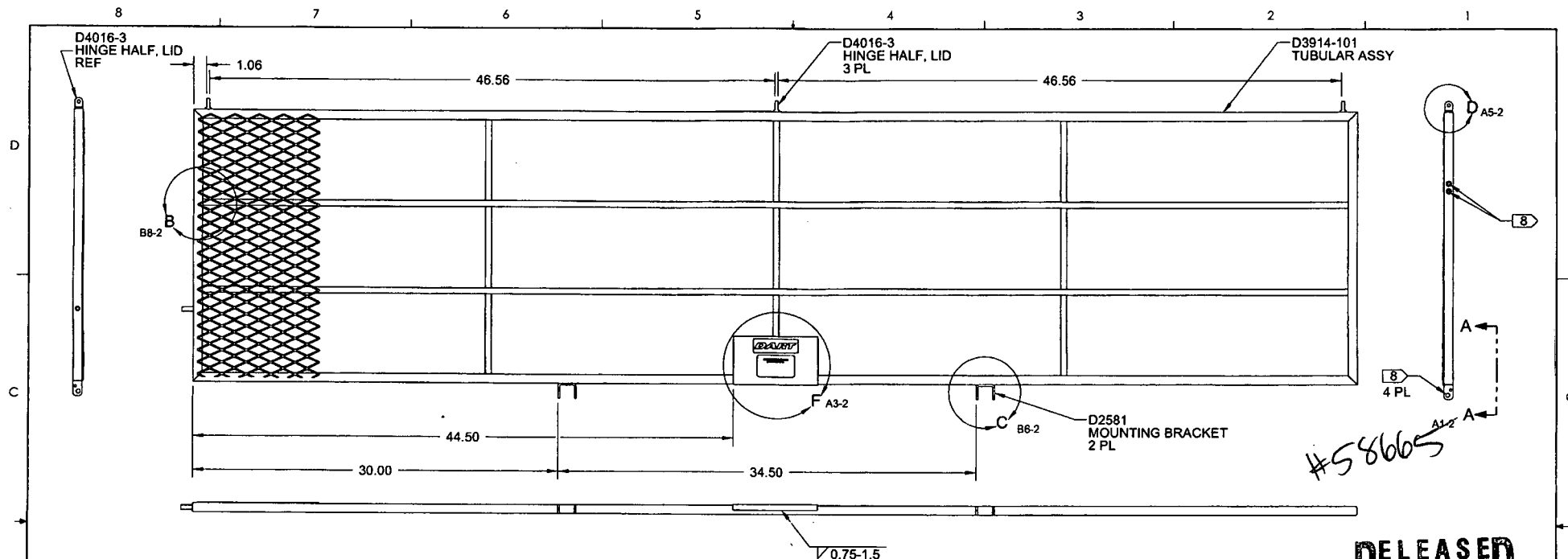
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

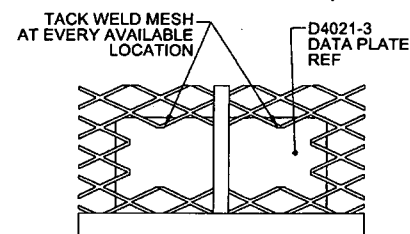
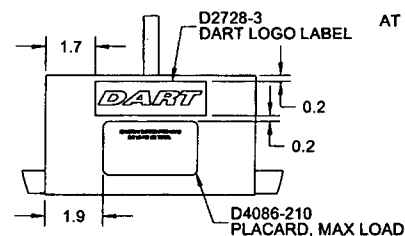
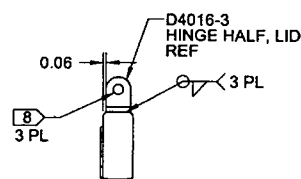
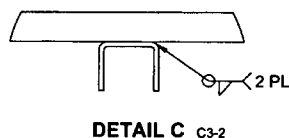
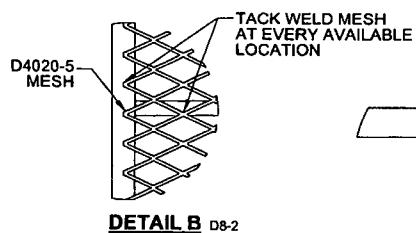
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**NOTE:** Date & initial all entries



**D3914-041 LONG BASKET LID ASSY (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)



**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3  
APPLY BLACK ANTI-SKID PAINT TO OUTSIDE SURFACE OF MESH PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 22.35 lbs APPROX
- 8) MASK HOLES PRIOR TO FINISHING
- 9) WELD PER DART QSI 004

DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3914	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET LID ASSY (350)	NTS
DATE	10.03.16	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISCLOSED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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2010-03-22

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

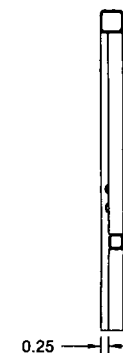
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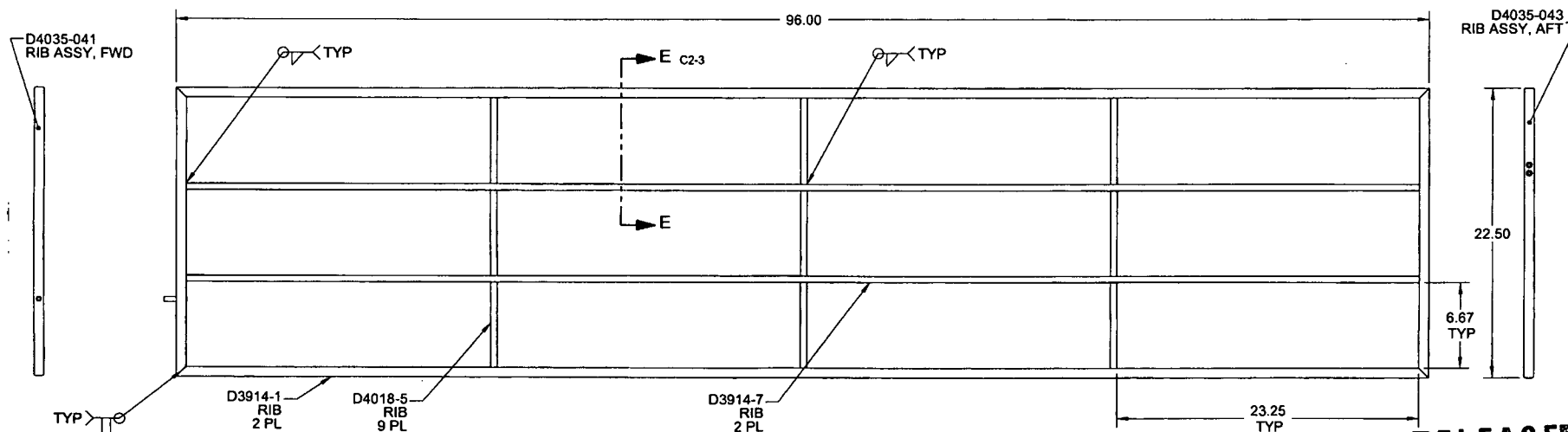
NOTE: Date & initial all entries



ITEM	QTY	P/N	DESCRIPTION
	X	D3914-101	TUBULAR ASSY, BASKET LID (350)
1	2	D3914-1	RIB
2	2	D3914-7	RIB
3	9	D4018-5	RIB
4	1	D4035-041	BASKET LID RIB ASSY, FWD
5	1	D4035-043	BASKET LID RIB ASSY, AFT



SECTION E-E C5-3



**RELEASED**  
2010-03-22  
Add

8 D3914-101 TUBULAR ASSY, LONG LID

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 14.10 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS  $\pm 0.06$  FOR D4018-101
- 9) WELD PER DART QSI 004

DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	A	DRAWING NO. <b>D3914</b>	REV. A
MFG. APPR.	[Signature]	TITLE <b>LONG BASKET LID ASSY (350)</b>	SHEET 3 OF 4
APPROVED	[Signature]	SCALE	NTS
DE APPR.	[Signature]	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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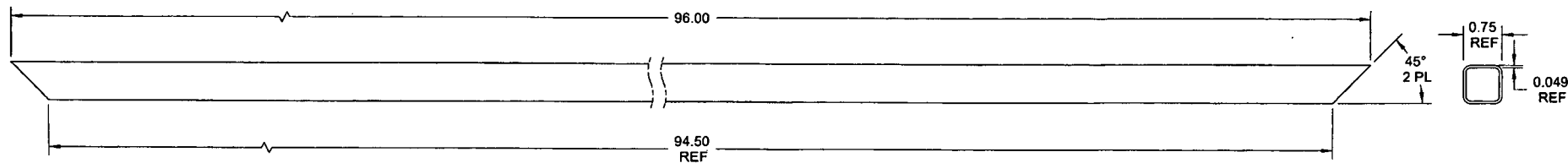
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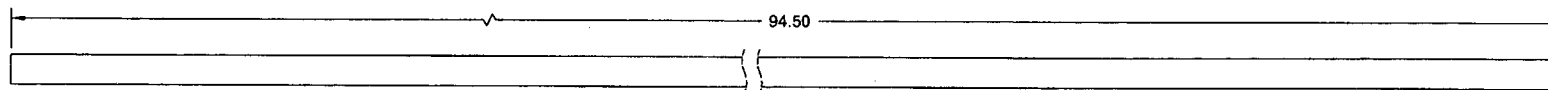
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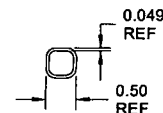
#58665



**D3914-1 RIB**



**D3914-7 RIB**



**NOTES:**

1) MATERIAL -1: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL  
REF DART SPEC. M304TS0.750W.049

-7: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL  
REF DART SPEC. M304TS0.500W.049

- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE ASSEMBLED WEIGHTS

**RELEASED**  
2010-03-22

DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3914	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET LID ASSY (350)	NTS
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